

Work Order ID: 76634

76634

Page 1

Friday, November 18, 2011 9:59:07 AM

Item ID: K10111 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, Skidtube 206
 Start Date: 11/18/2011 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 11/30/2011 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: [Signature] Date: 11-11-18 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9583	A
K10111	B

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP FOR D206-642-111 CHG007 FOR D206-642-113 CHG002		K10111	CHG003					

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

[Signature] MLT 11-12-8
 (5)

11/12/9 [Signature] 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76634***76634***

Page 2

Friday, November 18, 2011 9:59:07 AM

Item ID: K10111 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Skidtube 206
Start Date: 11/18/2011 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 11/30/2011 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		5-11-12-14		(x5)			
130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP PPP D206-642-111 PPP D206-642-113 Location: <u> </u> PPP rev: <u>F AR</u>	0.00 0.00							SP 11-12-14.
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/12/14 MF 11-12-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, November 18, 2011 9:59:11 AM

Work Order ID: 76634

76634

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: F01.11.08 Revised Step 5 and Added Inspection Level
21SM IPP REV:G
11.09.23 PER REV.B DD VERF:EC IPP REV:H 11.11.14
AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-41A
AN3-41A

Purchased	No				110	Each	1,655.000	8	40			
-----------	----	--	--	--	-----	------	-----------	---	----	--	--	--

**

Location	Loc Qty	Loc Code
----------	---------	----------

st510	1655	
119042	1655	

AN4-6A
AN4-6A

Purchased	No				110	Each	5,062.000	12	60			
-----------	----	--	--	--	-----	------	-----------	----	----	--	--	--

**

Location	Loc Qty	Loc Code
----------	---------	----------

ST356	62	
119127	62	
ST516	5000	
119017	5000	

AN4C5A
AN4C5A

Purchased	No				110	Each	489.0000	1	5			
-----------	----	--	--	--	-----	------	----------	---	---	--	--	--

**

Location	Loc Qty	Loc Code
----------	---------	----------

FP-B	49	
112243	49	
ST355	440	
112243	340	
119017	100	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Friday, November 18, 2011 9:59:12 AM

Work Order ID: 76634

76634

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

AN5-10A

Purchased

No

110

Each

872.0000

4

20

**

AN5-10A

Bolt

Location

Loc Qty

Loc Code

ST337

872

116704

11

118191

59

119547

802

110

Each

1,599.000

4

20

**

AN5-11A

Purchased

No

AN5-11A

Bolt

Location

Loc Qty

Loc Code

ST337

21

117313

2

118191

19

ST518

1578

119512

1578

110

Each

511.0000

2

10

**

AN6-44A

Purchased

No

AN6-44A

Bolt

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

504

119036

504

110

Each

1.0000

1

5

**

D206-651-041

Manufactured

No

D206-651-041

206A/B GHW

Location

Loc Qty

Loc Code

FG125

1

74002

1

Friday, November 18, 2011 9:59:12 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

Friday, November 18, 2011 9:59:12 AM

Work Order ID: 76634

76634

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

D2652 Manufactured No

110

Each

743.0000

16

80

**

41
B73834

D2652

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

699

73835

579

73836

120

39

D2661-1 Manufactured No

110

Each

18.0000

2

10

**

B76746

D2661-1

Saddle, LH Fwd Aft Out 206

Location

Loc Qty

Loc Code

MEZZ

5

64559

5

ST435

13

73838

10

73841

1

76516

2

B76747

D2662-1 Manufactured No

110

Each

20.0000

2

10

**

B76731 *11/18/11* *(S)*

D2662-1

Saddle, LH In 206

Location

Loc Qty

Loc Code

ST435

10

73846

1

74479

9

ST476

10

74481

10

Friday, November 18, 2011 9:59:12 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, November 18, 2011 9:59:12 AM

Work Order ID: 76634

76634

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

D2712

Manufactured No

110

Each

2,551.000

10

50

**

D2712

Self Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

2501

71160

1

73837

500

76065

2000

110

Each

100.0000

2

10

**

D2884

Manufactured No

D2884

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29453

10

ST025

90

73823

90

110

Each

126.0000

2

**

D2885

Manufactured No

D2885

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29199

10

ST025

116

73824

116

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 5

Friday, November 18, 2011 9:59:12 AM

Work Order ID: 76634

76634

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

D3413-1

Manufactured No

110

Each

94.0000

1

**

5
D

D3413-1

SS Ring

Location

Loc Qty

Loc Code

ST368

2

73821

2

ST420

2

66387

1

70773

1

ST469

88

73822

88

ST473

2

71041

2

5

MS21042L3

Purchased

No

110

Each

8,753.000

8

**

40

11/18/11

50

MS21042L3

SS Nut

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2498

119075

2498

40

Friday, November 18, 2011 9:59:12 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

Friday, November 18, 2011 9:59:12 AM

Work Order ID: 76634

76634

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

110

Each

11,450.00

12

60

MS21042L4

**

Location

Loc Qty

Loc Code

ST300

558

117441

51

117601

374

118451

133

ST516

5892

119017

5892

ST518

5000

119075

5000

MS21042L6

Purchased

No

110

Each

1,484.000

2

10

MS21042L6

**

Location

Loc Qty

Loc Code

ST300

484

117677

25

118384

5

118927

48

118968

406

ST518

1000

119075

1000

NAS1149C0463R

Purchased

No

110

Each

1,379.000

1

5

NAS1149C0463R

**

Location

Loc Qty

Loc Code

FP-B

1

115358

1

ST297

1378

117735

378

119097

1000

Friday, November 18, 2011 9:59:12 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Friday, November 18, 2011 9:59:12 AM

Work Order ID: 76634

76634

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0363J

Purchased

No

110

Each

4,434.000

8

40

NAS1149D0363.I

**

Washer

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

1418

117601

148

118077

1

118612

55

118968

1214

NAS1149D0463J

Purchased

No

110

Each

12,582.00

24

120

NAS1149D0463.I

**

Washer

Location

Loc Qty

Loc Code

ST019

25

118179

25

ST298

299

116025

16

116805

0

117291

1

117460

2

118179

17

118384

249

118612

3

119042

11

ST407

12258

119075

10000

119097

2258

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist.Print

Page 8

Friday, November 18, 2011 9:59:12 AM

Work Order ID: 76634

76634

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0563J

Purchased

No

110

Each

5,121.000

8

40

**

NAS1149D0563.I

Washer

Location

Loc Qty

Loc Code

ST296

2000

119546

2000

ST298

3121

118206

2121

118614

1000

NAS1149D0663J

Purchased

No

110

Each

2,598.000

4

20

**

NAS1149D0663.I

Washer

Location

Loc Qty

Loc Code

ST407

2598

119075

2598

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>140</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>FE</i>	K10111	SHEET 1 OF 1
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	SADDLE KIT	NTS
DATE	11.11.10	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	